

Date: Tuesday, 15/07/2008 9:13:58 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR FWD RH
Job Number : 40473	
Estimate Number : 11234	
P.O. Number :	Part Number : D32812
This Issue : 15/07/2008 S.O. No. :	Drawing Number : D3281 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : D
Previous Run : 39995	Material :
Written By :	Due Date : 30/07/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.15.08</u>	
Comment : Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Est Rev C 08.02.06 To reflect updated dwg. DL Est. Rev D 08.04.15 Material Change DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number M106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

08/07/16 X 10 BB

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 008

Dwg. Rev. P

Folio Rev. C

BB. 08/07/17 X 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:13:58 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD RH

Job Number: 40473

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/07/22 X10

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/07/22 X10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/07/22 (X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

BB 08/07/22 (X10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22 (X10)

Job Completion



MF 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Fwd RH		Part Number:	D3281-2
Inspection Dwg: D3281	Rev: <u>D 9/08 0715</u>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: <u>08/07/17</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3	✓			
17.4	+/-0.100	17.45	✓			
12.1	+/-0.100	12.125	✓			
0.95	+/-0.030	.966	✓			
0.25	+/-0.030	.259	✓			
0.030	Min	.89	✓			
0.070	+/-0.010	.79	✓			

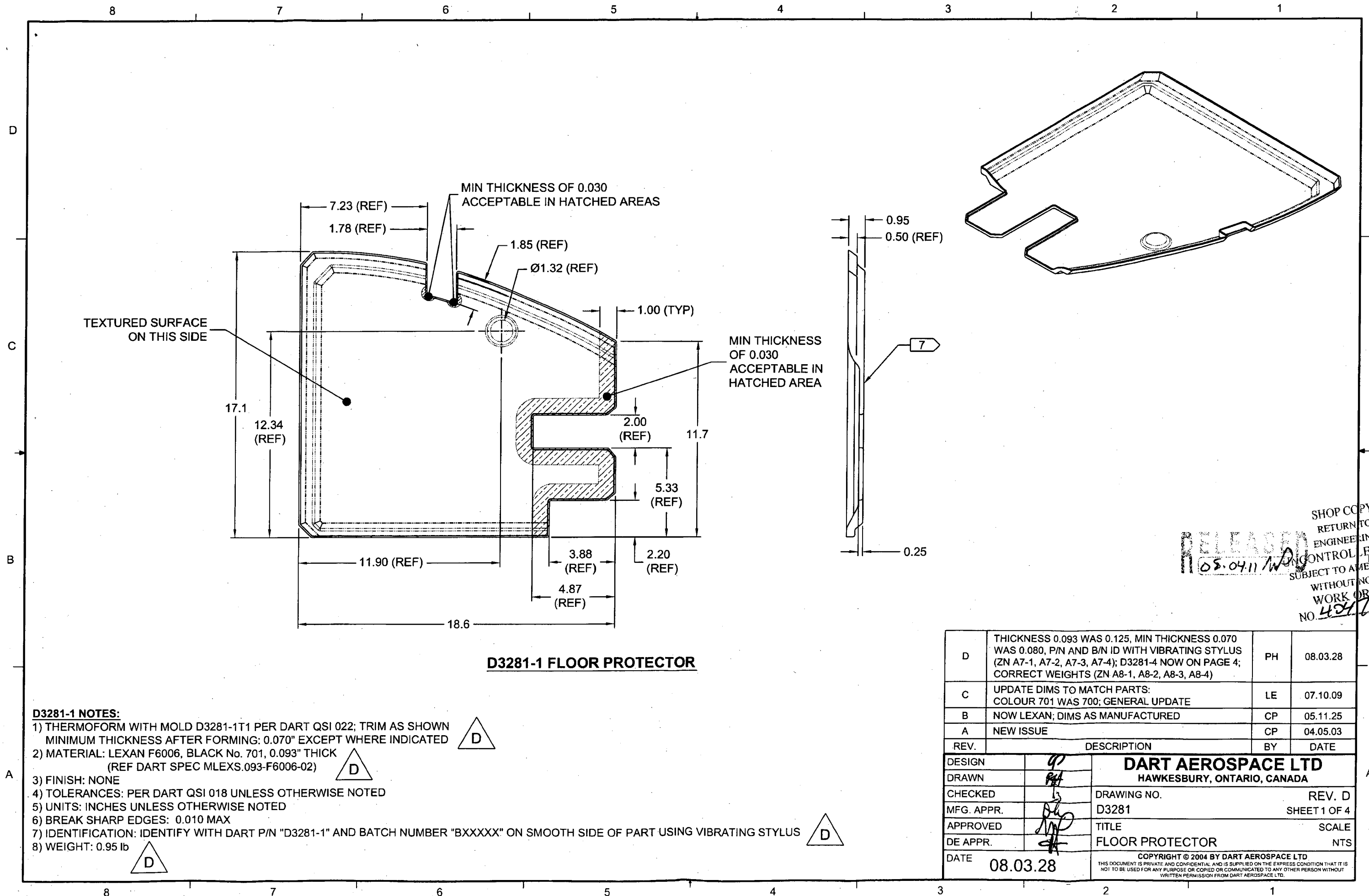
Measured by: <u>BB</u>	Date: <u>08/07/17</u>
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Audited by: <u>Dh</u>	Date: <u>08.02.17</u>
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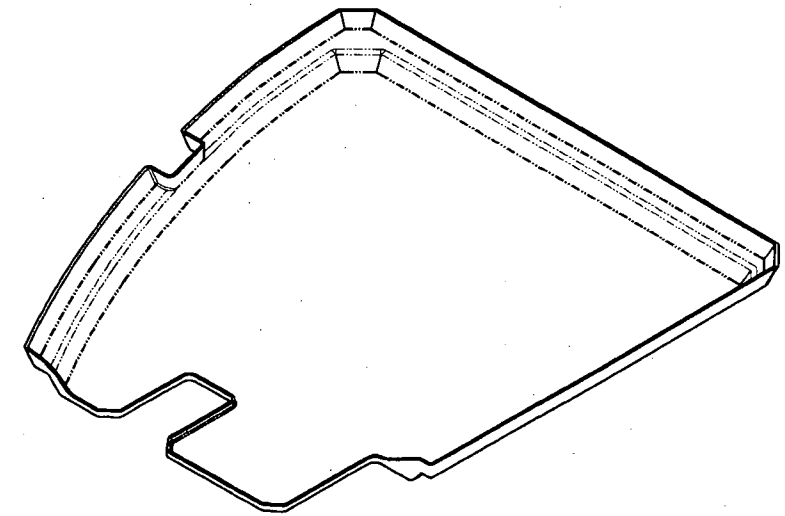
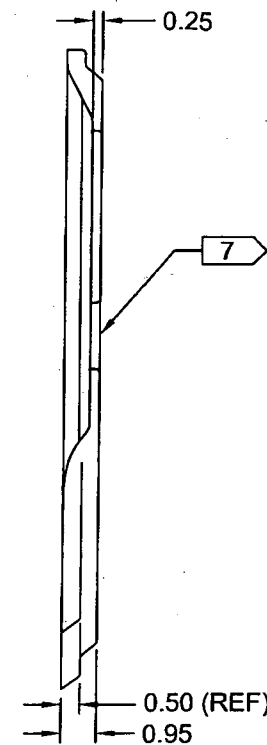
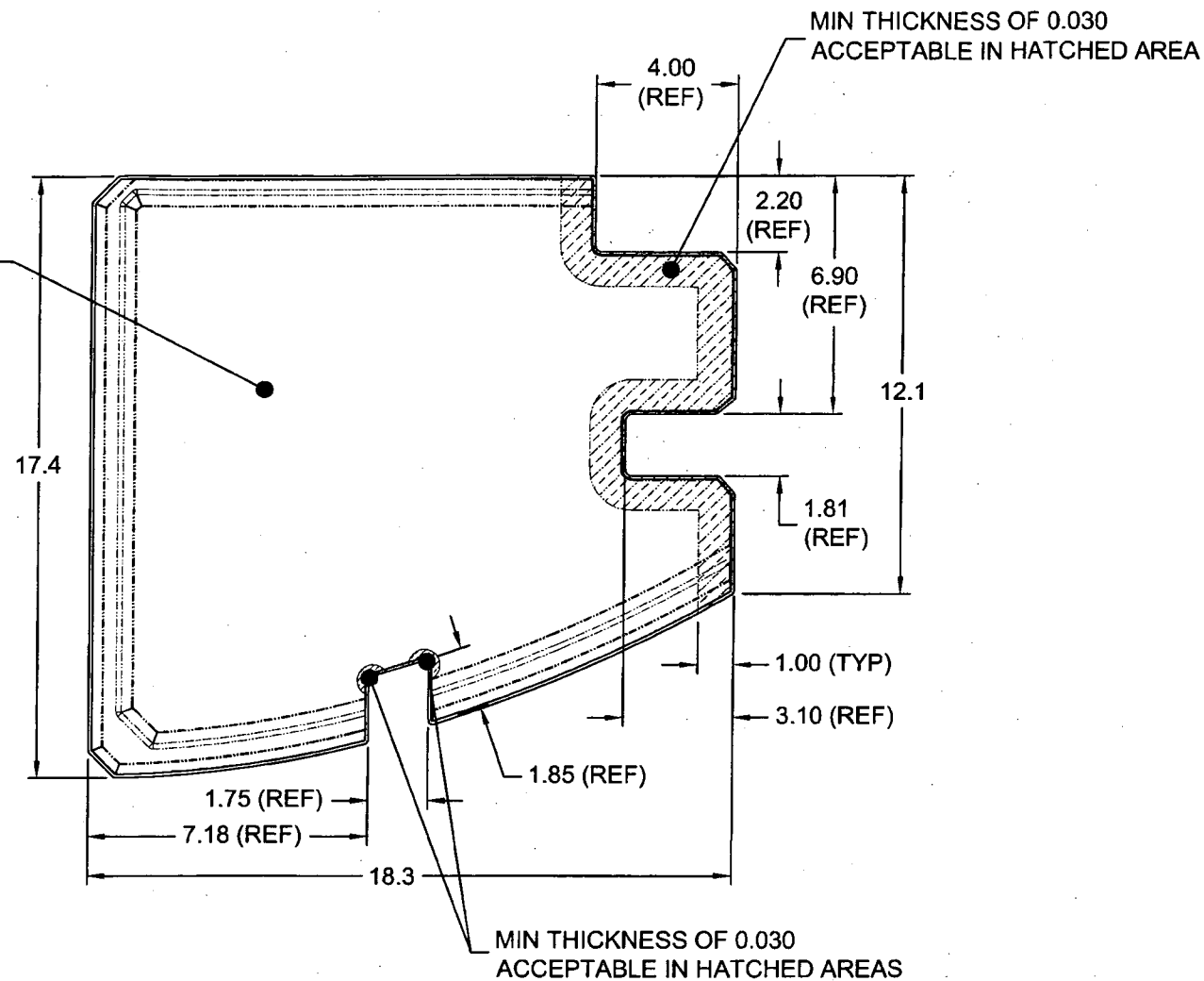
Prototype Approval: N/A	Date: N/A
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Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <u>JA</u>	<u>BE</u>

JA



TEXTURED SURFACE
ON THIS SIDE



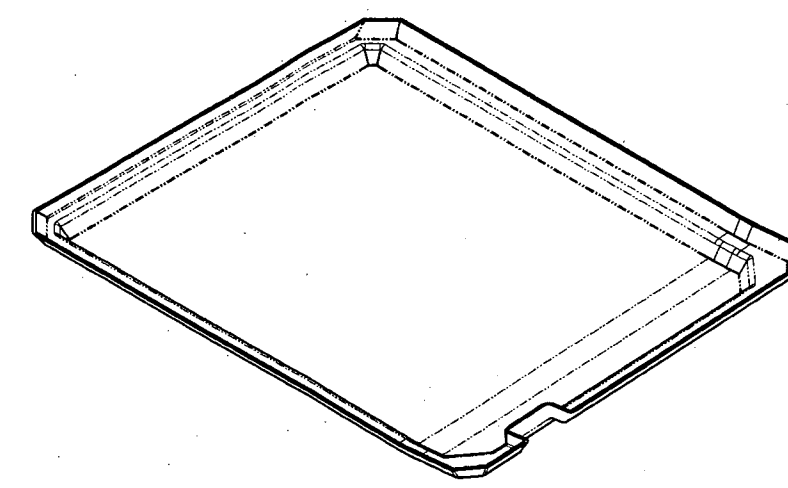
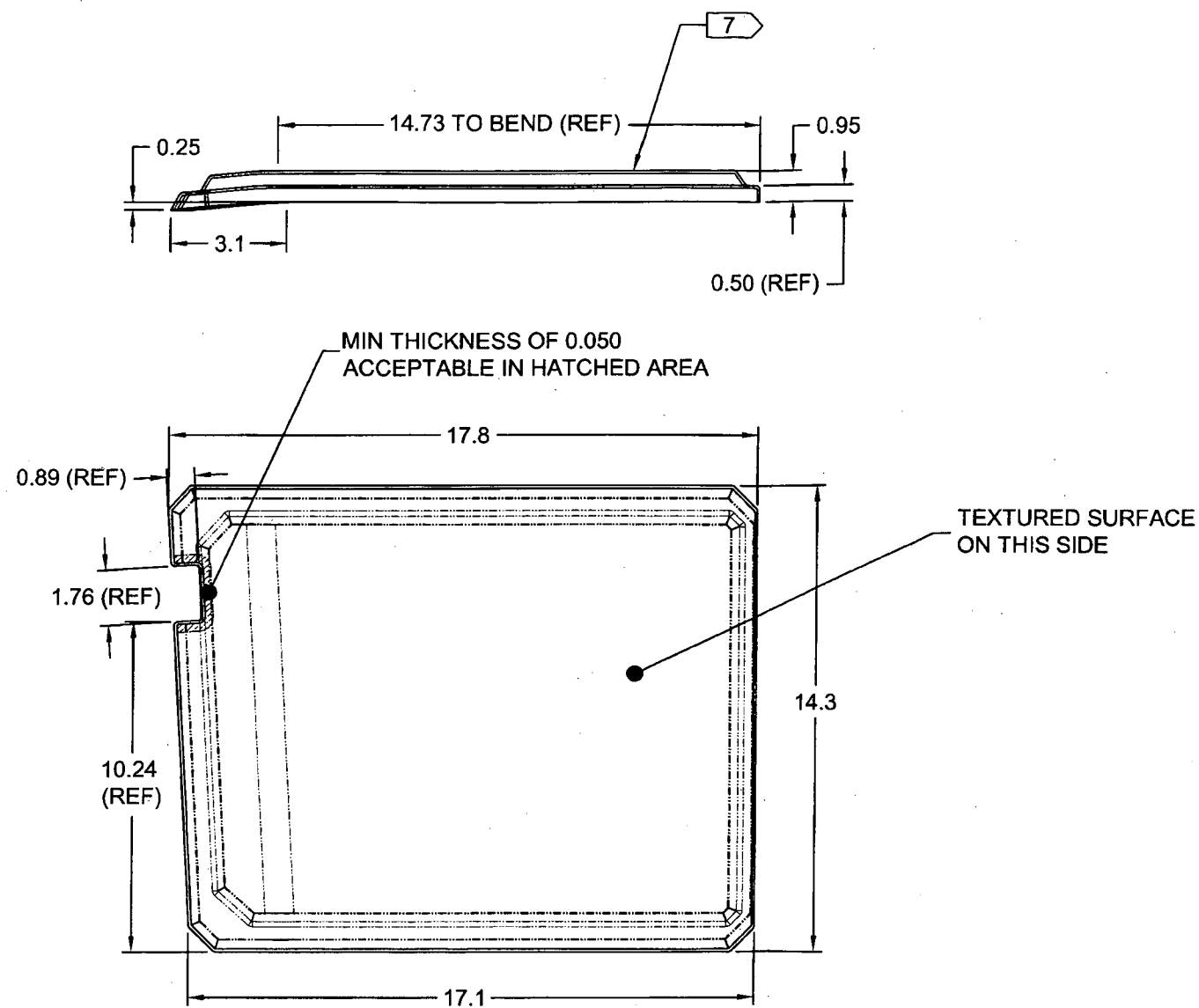
D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

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WORK ORDER
NO. 40473

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

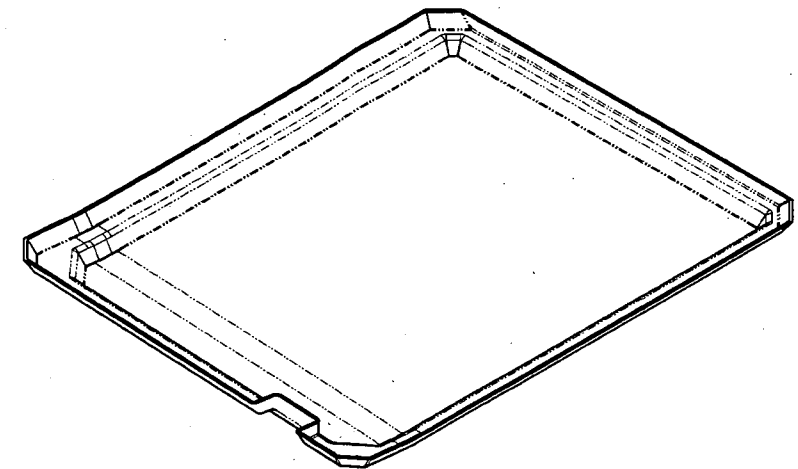
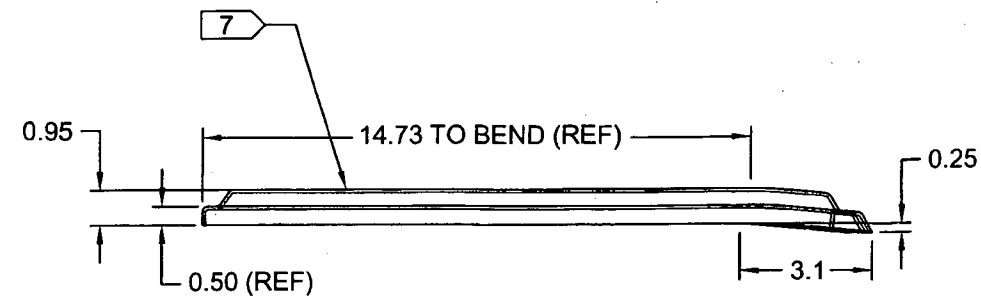
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	MD	D3281	SHEET 3 OF 4
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DE APPR.	MD	FLOOR PROTECTOR	NTS
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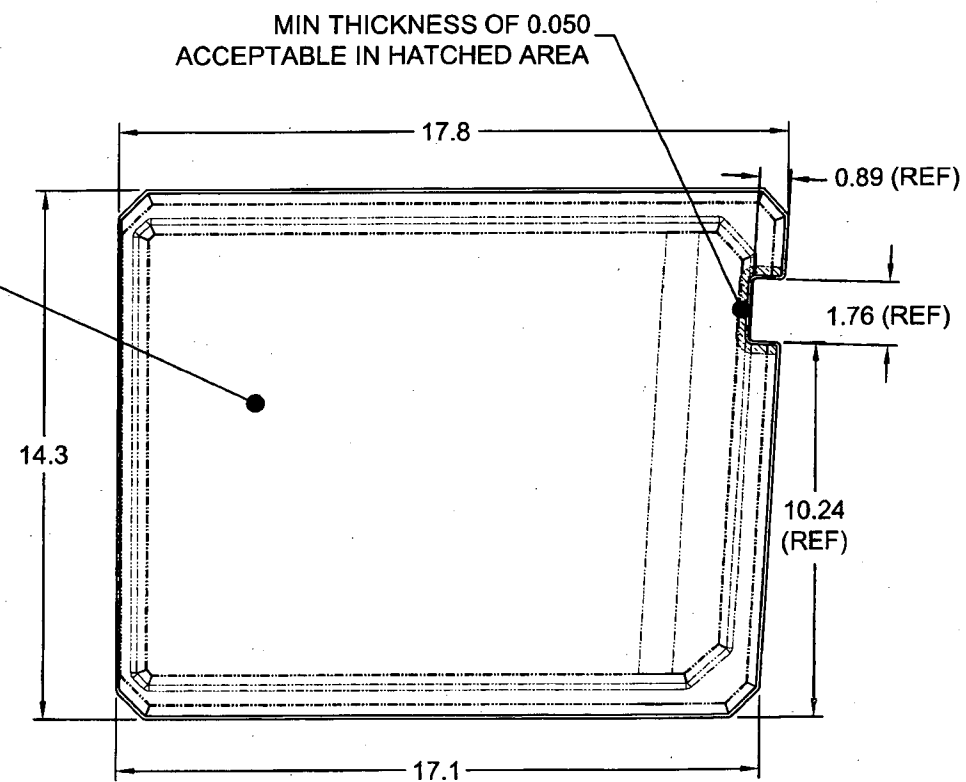
D



D

C

TEXTURED SURFACE
ON THIS SIDE



C

B

B

D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



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8 7 6 5 4 3 2 1